

Work Order ID 52657

October 5, 2009 2:53:16 PM



Page 1

Item ID: D3572-5

Accept



Setup Start



Revision ID: D

Stop



Item Name: Bracket

Start Date: 09/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: BP Date: 09-10-5 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3572 | Rev D |

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3572 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Debur if necessary

6661
.08x

BP 9-11-5

(14)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

BP 9-11-5

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

⇒ 8.02/11/05

(84)

Work Order ID 52657

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Page 3

Item ID: D3572-5

Accept



Setup Start



Revision ID: D

Stop



Item Name: Bracket

Start Date: 06/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/19

Plt 09-11-19
(14)

Picklist Print

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Page 1

Work Order ID: 52657



Parent Item: D3572-5RevD



Parent Item Name: Bracket

Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

M6061T6S.080

Purchased

No

sf

302.7094

0.3002

5



18911-5

6061-T6 .080 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

302.7094

107904

0.02

110254

2.5

110630

38.0926

112040

0.0437

112141

33

112512

37.0531

112763

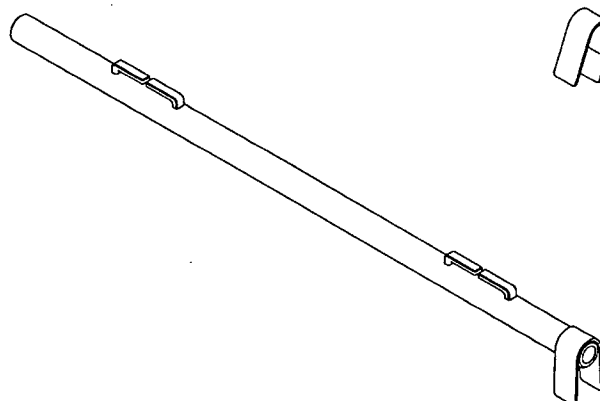
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112763

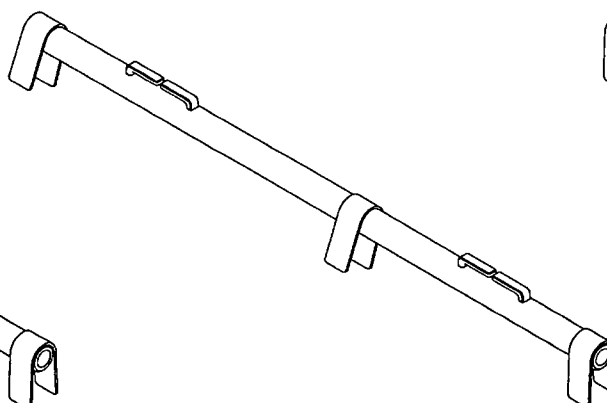
| ITEM No. | QTY -041 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|----------|----------|----------|----------|-------------|-----------------------------|
| 1 | X | | | D3572-041 | GUIDE ASSEMBLY |
| 2 | | X | | D3572-043 | GUIDE ASSEMBLY (UH-1) |
| 3 | | | X | D3572-044 | GUIDE ASSEMBLY (UH-1) (OPP) |
| 11 | 1 | 1 | 1 | D3572-1 | TUBE |
| 12 | 4 | 4 | 4 | D3572-3 | GUIDE |
| 13 | 1 | 3 | 3 | D3572-5 | BRACKET |
| 14 | - | - | - | D3572-7 | DELETED AT REV C |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52657
BL 09-10-5

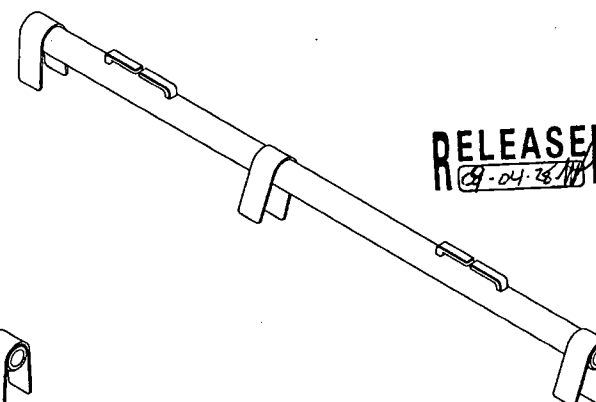
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09-04-28-18



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



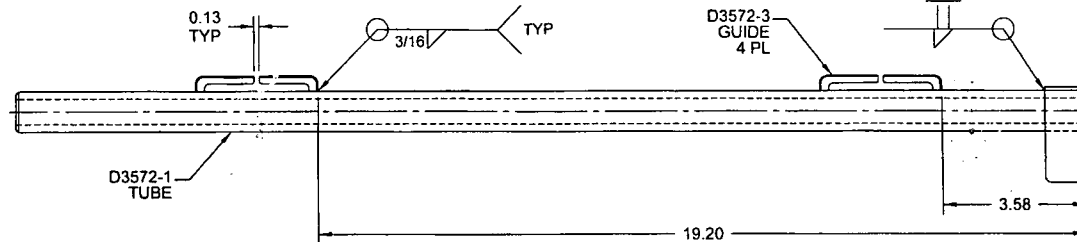
D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:

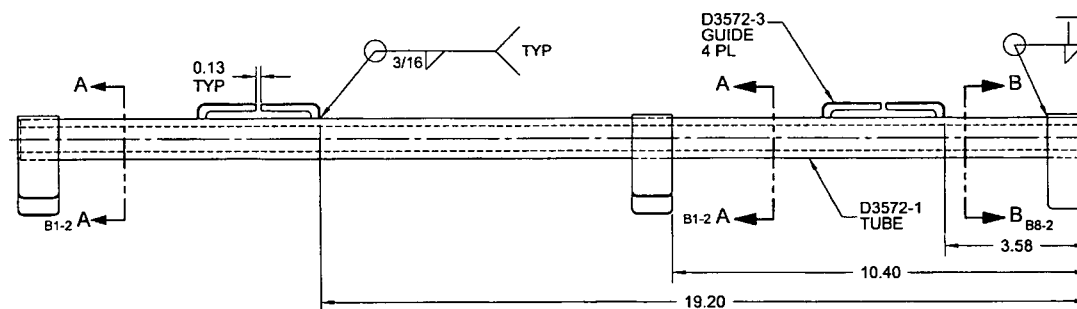
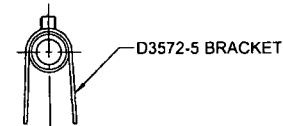
- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

| D | REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017. | AJS | 09.04.17 |
|------------|---|--|--------------|
| C | REMOVE D3572-7 | LE | 07.06.01 |
| B | FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET | LE | 07.04.20 |
| A | NEW ISSUE | LE | 07.03.29 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. D |
| MFG. APPR. | <i>[Signature]</i> | D3572 | SHEET 1 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | GUIDE ASSEMBLY | NTS |
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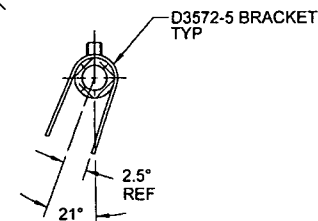
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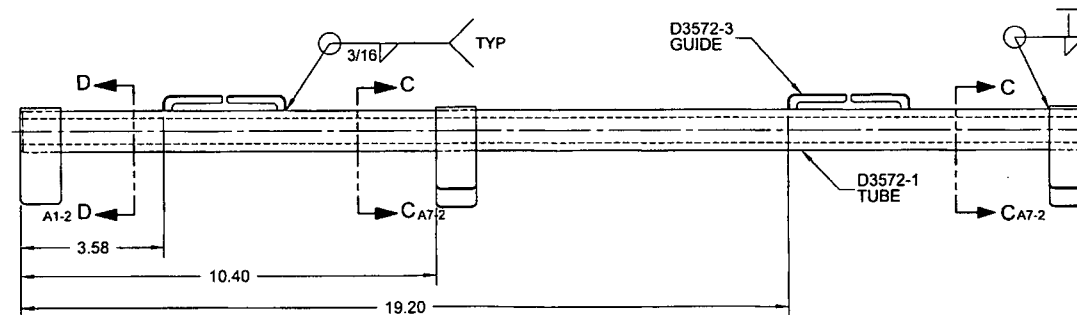
D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY

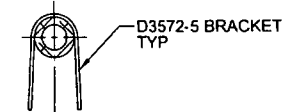


SECTION A-A C7-2
C4-2
(2 PL)

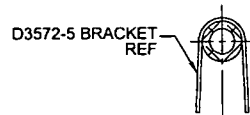


D3572-044 GUIDE ASSEMBLY

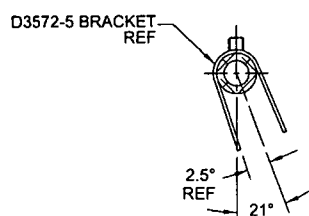
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09.04.17



SECTION D-D A7-2



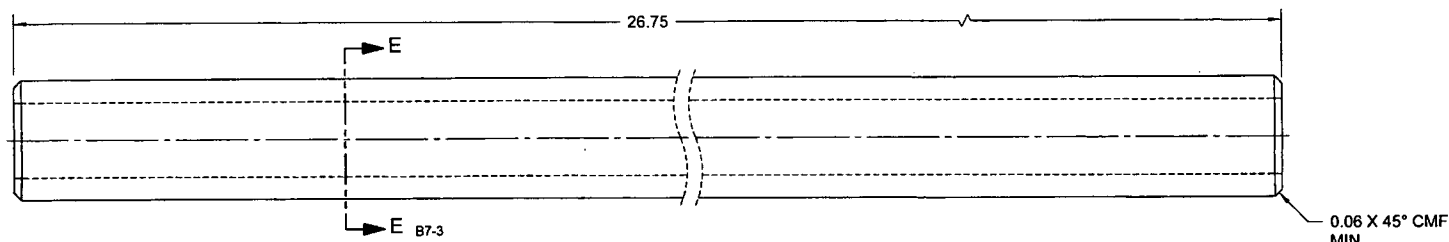
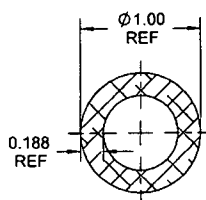
SECTION B-B C2-2



SECTION C-C A2-2
A5-2

| | | | |
|------------|----------|---|--------------|
| DESIGN | LE | DART AEROSPACE LTD | |
| DRAWN | A.S. | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | A | DRAWING NO. | REV. D |
| MFG. APPR. | B | D3572 | SHEET 2 OF 4 |
| APPROVED | H | TITLE | SCALE |
| DE APPR. | H | GUIDE ASSEMBLY | NTS |
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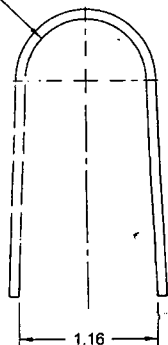
RELEASED
07/04/17

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

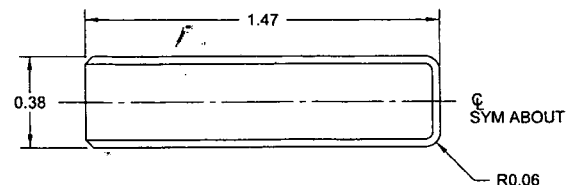
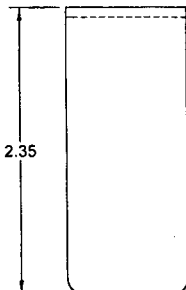
| | | | |
|------------|----------|---|--------|
| DESIGN | LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | h | DRAWING NO. D3572 | REV. D |
| MFG. APPR. | h | SHEET 3 OF 4 | |
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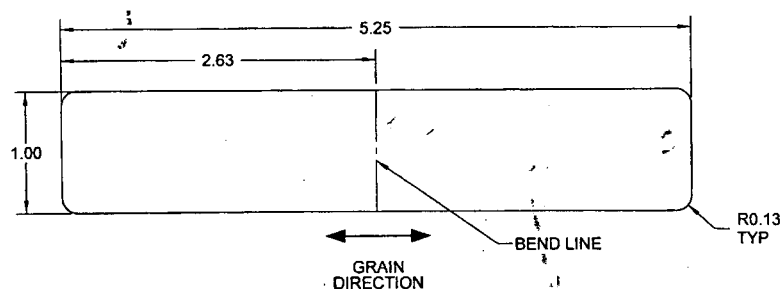


D3572-5 BRACKET
(MAKE FROM D3572-5F)

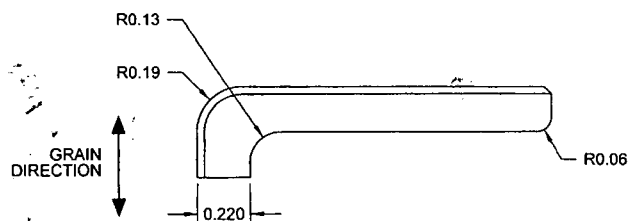
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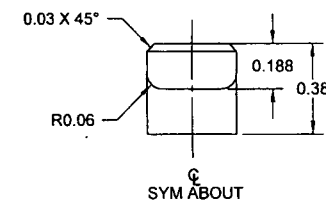
w/o 52457



D3572-5F FLAT PATTERN



D3572-3 GUIDE



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9/13/17

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | LE | DART AEROSPACE LTD | |
| DRAWN | AS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D3572 | SHEET 4 OF 4 |
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